

Work Order ID 118942

118942

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Item ID: D3791-1 Accept *N900040100* Setup Start *NS1*
 Revision ID: Stop *NS2*
 Item Name: Wearpad
 Start Date: 5/05/14 Start Qty: 20.00 *20* Cust Item ID:
 Required Date: 5/05/14 Req'd Qty: 20.00 *20* Customer:
 Reference:

Approvals: Process Plan: W Date: _____ Tooling: _____ Date: _____ Run Start *NR1*
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3791	Rev A								

105

0.00

105

Purchasing

Purchasing

Memo

ISSUE PO 24577
 CUT PER DRWG D3791 REV.A

0.00

CY 14/06/12 20

115

Receive & Inspect for Damage & Mat'l Certs

0.00

115

Packaging

Packaging

Memo

0.00

P 14/7/4 (20)

125

QC6- Inspect dimensions to drawing

0.00

125

QC

Quality Control

Memo

0.00

20 0

DAS
 23
 9-88

14-07-7

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Item ID: D3791-1

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Wearpad

Start Date: 5/05/14 Start Qty: 20.00

20

Cust Item ID:

Required Date: 5/05/14 Req'd Qty: 20.00

20

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start *NR1*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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130

0.00

130

Brake NC

NC BRAKE

Memo

0.00

DAS
30
9-89

20

14/07/8

Brake NC

1-Deburr if necessary

2-Form on Brake as per Dwg D3791 using Jigs

140

0.00

140

QC

QC5- Inspect part completeness to step on W/O

Memo

0.00

Quality Control

Ensure joggle as per dwg D3429

SMP
14/7/8

20

150

0.00

150

Large Fab

Large Fab

Memo

0.00

Large Fab

1-Weld hardcoat as per dwg D3791 QSI004

Hardcoat 2059b Batch: m129649

20

14-08-19 MAL/PL

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Item ID: D3791-1

Revision ID:

Item Name: Wearpad

Start Date: 5/05/14 Start Qty: 20.00

Required Date: 5/05/14 Req'd Qty: 20.00

Reference:

Accept

N900040100

Setup Start *NS1*

Stop *NS2*

Cust Item ID:

Customer:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start *NR1*

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Std
160	QC10- Inspect visual per QSI004- ground welds	0.00				20	14-8-21		DAS 50 9-89
160									
QC	Memo	0.00							
Quality Control									
170	QC5- Inspect part completeness to step on W/O	0.00				20	14-8-21		DAS 50 9-89
170									
QC	Memo	0.00							
Quality Control									
180	Grey Sandtex(Ref:4.3.5.6) per QSI005 4.3	0.00				20	14-8-21		DAS 34 9-89
180									
Powdercoat	Memo	0.00							
Powder Coating									
	START TIME: 2:20								
	OVEN TEMPERATURE: 300								
	FINISH TIME: 2:00								

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Item ID: D3791-1

Accept

N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Wearpad

Start Date: 5/05/14

Start Qty: 20.00

20

Cust Item ID:

Required Date: 5/05/14

Req'd Qty: 20.00

20

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

190

QC3- Inspect Part Finish

0.00

190

QC

Memo

0.00

Quality Control

20

2

24

14/08/21

200

Identify as per dwg & Stock Location: FP-002

0.00

200

Packaging

Memo

0.00

Packaging

x20

4

24

14/08/22

210

QC21- Final Inspection - Work Order Release

0.00

210

QC

Memo

0.00

Quality Control

ML5

14-08-22

ML5

14-08-22

Picklist Print

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Work Order ID: 118942

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Parent Item: D3791-1

D3791-1

Parent Item Name: Wearpad

Start Date: 5/05/14

Required Date: 5/05/14

Start Qty: 20.00

Required Qty: 20.00

Comments: IPP Rev:A 08-05-13 new issue DD verified by:EC
IPP Rev:B 08-05-22 revA as per dwg ECN1191 DD verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304S16GA		Purchased	No			100	sf	144.8670	0.2917	7			

M304S16GA

304/316 Sheet .063

**

C214/06/19

Location

Loc Qty

Loc Code

MAT020

144.867

M127821

75.567

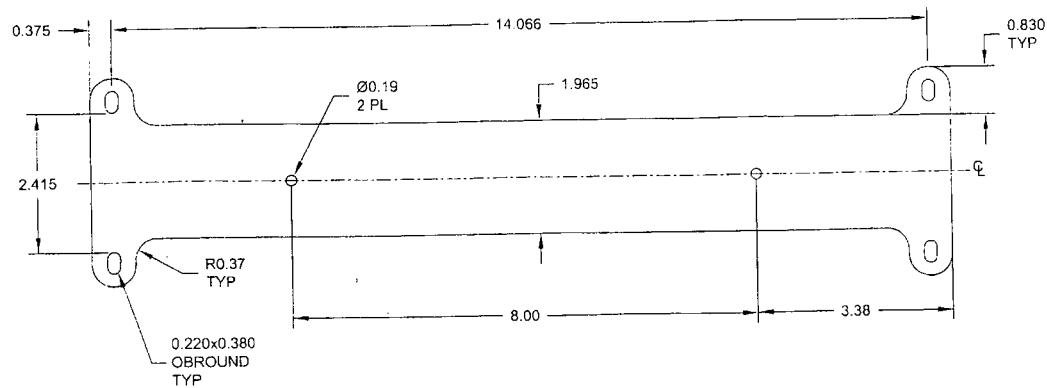
M128423

1.2

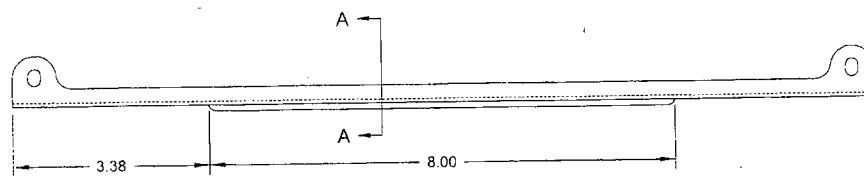
M129192

68.1

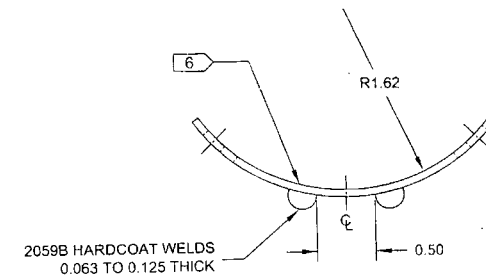
M129545



D3791-1F FLAT PATTERN



D3791-1 WEARPLATE
(MAKE FROM D3791-1F)



SECTION A-A
SCALE 2X

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 118942 MLS 14-05-07

RELEASED
08-05-21/116

NOTES:

- 1) MATERIAL: AISI 304/316 SS SHEET PER AMS 5513 OR AMS 5524, 16 GAUGE (0.063 THICK)
(REF. DART MATERIAL SPEC M304S16GA)
- 2) FINISH: POWDER COAT GREY SANDTEX (4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.015
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3791-1" ON INSIDE SURFACE USING FINE POINT PERMANENT INK MARKER OR LABEL AFTER FINISH
- 7) WEIGHT: 0.70 LBS
- 8) WELD PER DART QSI 004

REV.	NEW ISSUE	DESCRIPTION	PH	08.05.13
DESIGN	PH	DART AEROSPACE USA, INC	BY	DATE
DRAWN	PH	PORT HADLOCK, WA		
CHECKED		DRAWING NO.	REV. A	
MFG. APPR.		D3791	SHEET 1 OF 1	
APPROVED		TITLE	SCALE	
DE APPR.		WEARPLATE	NTS	
DATE	08.05.13	COPYRIGHT © 2008 BY DART AEROSPACE USA, INC THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSES OR COMPLETED OR OTHERWISE REPRODUCED IN ANY MANNER WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.		

T.P.I. INDUSTRIES INC.

148 GOODFELLOW
 DELSON, QUÉBEC J5B 1V4
 CANADA
 Tel: (450) 633-0484
 Fax: (450) 633-0879

Packing Slip

Packing Slip No.: 6177
 Date: 2014-07-02
 Page: 1

Sold to:	Ship to:
Dart Aerospace Michael Grégoire 1270 Aberdeen Hawkesbury, Ontario K6A 1K7 Canada	Dart Aerospace Michael Grégoire 1270 Aberdeen Hawkesbury, Ontario K6A 1K7 Canada
Order No.: 24577	Sold By: JONATHAN LESSARD
Shipped By:	Ship Date: 2014-07-02
Tracking No.:	

Item No.	Unit	Description	Quantity
d3564-5	Chaque	d3564-5	24
d3564-9	Chaque	d3564-9	24
d3564-11	Chaque	d3564-11	24
d3791-1	Chaque	d3791-1 wearpad	24
d3537-3	Chaque	d3537-3 wearpad	24
d3537-1	Chaque	d3537-1 wearpad	40
d3537-1	Chaque	d3537-1 wearpad	60
d3791-1	Chaque	d3791-1 wearpad	60
d2154	Chaque	d2154 bracket stud	20
d2144	Chaque	d2144 hinge doubler	40
d4095-045	Chaque	d4095-045 wearplate assy	40
d4095-043	Chaque	d4095-043	12
d4095-041	Chaque	d4095-041 wearplate assy	12
d3859-041	Chaque	d3859-041 wearplate	12
d4952-1	Chaque	d4952-1 wearplate	16
d4095-051	Chaque	d4095-051 wearplate assy	20
d4095-049	Chaque	d4095-049 wearpad	20
d4095-047	Chaque	d4095-047 wearplate assy	16
d4798-041	Chaque	d4798-041 wearplate assy	20
d4135-1	Chaque	d4135-1 wearpad	16
d4360-041	Chaque	d4360-041 wearplate assy	10
d2012-111	Chaque	d2012-111 bracket	8
d2324-5	Chaque	d2324-5 strap	40
d2947	Chaque	d2947 clamp	40
d3171-1	Chaque	d3171-1 angle bracket	60
d3463-3	Chaque	d3463-3 step	20
d3512-1	Chaque	d3512-1 wearplate	12
d3629-1	Chaque	d3629-1 bracket	16
d3955-5	Chaque	d3955-5 plate	20
d4021-5	Chaque	d4021-5 blanking plate	12
d3556-1	Chaque	d3556-1 clamp	40

Comment: Net / 30 from date of invoice 2% svc. chg. on invoices over 30 days